

Work Order ID 69897

Tuesday, May 24, 2011 10:05:02 AM



Page 1

Item ID: D3371-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Base

Start Date: 5/24/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *11-05-24*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3371	Rev B								
100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank: 2.00" x 2.25" x 7.370" long								
110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine D3371-1 as per Folio FA486 and Dwg D3371 □ Debur □ Finish 8-32 thread by hand □ Identify as D3371-1								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

mf 11/07/07

4

B.A 11/07/18

4

B.A 11/07/18

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: ☒ Yes ☐ No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		third operation X axis position off by .015" in program. EC.	T.07.18	Corrected in network ACCEPTABLE. FIX AS REQ'D BY ASSEMBLY.	11.11.18	W.07.18	W.07.18	W.07.18
				N/A	13.07.18			

NOTE: Date & initial all entries

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Page 3

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Item Name: Pedal Lock Base

Start Date: 5/24/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 4 21 11/02/19

160

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

SB 11/02/19

(4)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/20 11/7/20

MF 11-07-19

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 10:04:54 AM

Page 1

Work Order ID: 69897



Parent Item: D3371-1



Parent Item Name: Pedal Lock Base

Start Date: 5/24/2011

Required Date: 6/10/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A ☐ 05.01.18 ☐ New issue ☐ KJ/JLM ☐ IPP RevB: add powdercoat DD
10.01.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.25 0		Purchased	No			100	f	0.0000	0.625	2.631579			



6061-T6 Bar 2.00 x 2.25

M118072 x 2.64" MR 11/07/07

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DART AEROSPACE LTD		Work Order:	19897
Description: Pedal Lock Base		Part Number:	D3371-1
Inspection Dwg: D3371 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
60°	+/-0.5°	60°	✓		Angle prot.	CNC-08
2.25	+/-0.030	2.251	✓		Vern	GA-01
1.650	+/-0.010	1.653	✓		"	"
1.648	+/-0.010	1.650	✓		"	"
0.700	+/-0.010	0.701	✓		D-6	GA-08
3.955	+/-0.010	3.955	✓		Vern	GA-01
0.600	+/-0.010	0.602	✓		H-6	31006
0.104	+/-0.010	0.110	✓		Vern	GA-01
0.305	+/-0.010	0.300	✓		"	"
45°	+/-0.5°	45°	✓		Angle prot.	CNC-08
0.672	+/-0.010	0.668	✓		Vern	GA-01
Ø1.300	+/-0.010	Ø1.299	✓		"	"
1.450	+/-0.005	1.450	✓		"	"
7°	+/-0.5°	7°	✓		Angle prot.	CNC-08
2.00	+/-0.030	1.999	✓		Vern	GA-01
1.125	+/-0.010	1.124	✓		"	"
Ø1.125	+/-0.010	Ø1.126	✓		"	"
R0.500	+/-0.010	R0.500	✓		R-6	ref.
1.000	+/-0.010	0.999	✓		Vern	GA-01
0.375	+/-0.010	0.374	✓		"	"
Ø0.203	+0.005/-0.000	Ø0.206	✓		"	"
7.19	+/-0.030	7.186	✓		Vern	CNC-02
4.500	+/-0.010	4.499	✓		Vern	GA-01
0.500	+/-0.010	0.500	✓		"	"

Measured by: J.A.	Audited by: SL	Prototype Approval:	N/A
Date: 11/07/18	Date: 11-07-18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Revised dimensions	KJ/JLM	

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

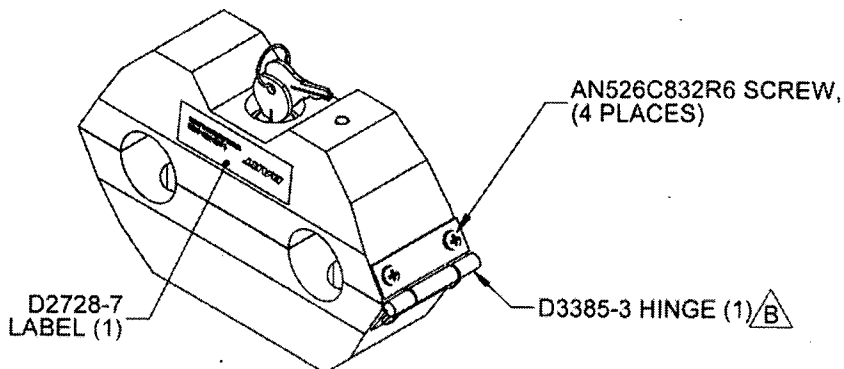
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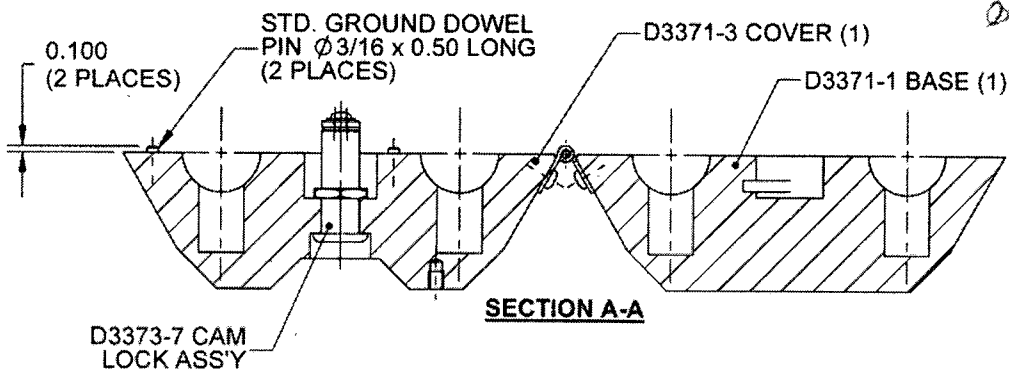


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



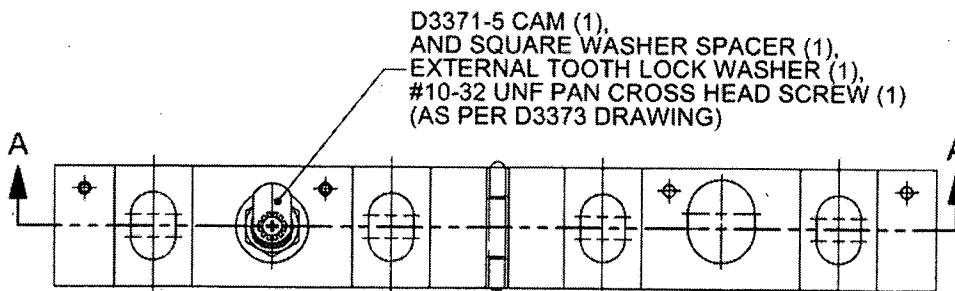
PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
[Signature]
05/04/28



SECTION A-A

#69887



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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NOTE: Date & initial all entries

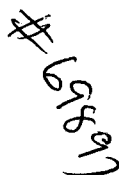
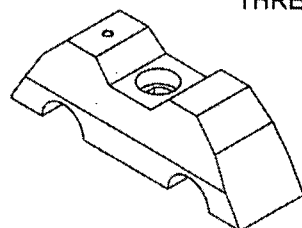
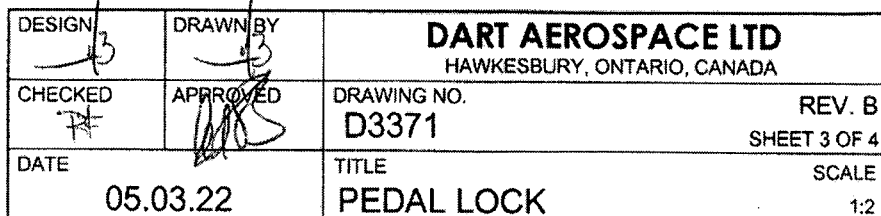
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NOTE: Date & initial all entries



- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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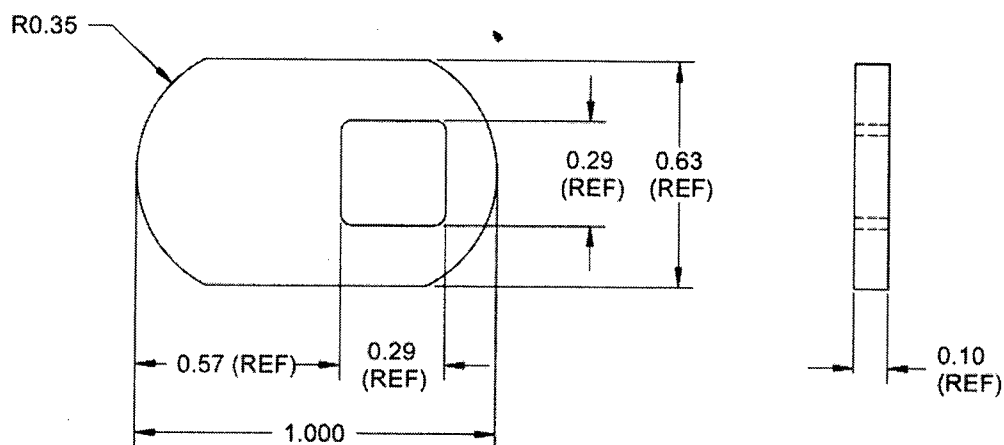
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/28

SPECIFICATION CONTROL DRAWING



#6889

D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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